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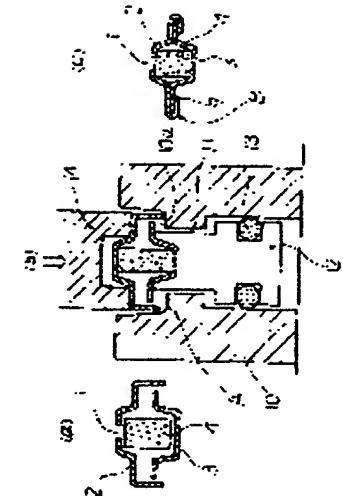
AOKI MASAYOSHI

(54) SEALING PARTS ASSEMBLY EQUIPMENT OF CYLINDRICAL BATTERY

(57)Abstract:

PURPOSE: To simplify equipment and reduce defectives by placing a safety valve between a sealing plate having a gas venting hole and a terminal cap and crimping the terminal cap with the periphery of the sealing plate which is formed so as to surround the periphery of the terminal cap.

CONSTITUTION: A crimping table center 12 is set through an O-ring 13 in the hole which passes through the center of a concavity 10a installed on the upper side of a crimping table 10. A terminal cap 3, a rubber safety valve 4, and a sealing plate 2 are placed on the crimping table center 12 in order. They are pressed from the upper side with a crimping punch 14 having concavity in its lower side with the terminal cap 3 floated from the concavity of the crimping table 10. The periphery of the sealing plate 2 is crimped along the radius formed in the part A of the concave 10a so as to surround the periphery of the terminal cap. Since a sealing part is obtained by one step crimping, equipment is simple and inexpensive, and also the quality of the part obtain is stable because of no displacement of crimping position.



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